

Work Order ID 60267

July 1, 2010 8:17:11 AM



Page 1

Item ID: D3119-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Cover Assembly

Start Date: 7/01/10 Start Qty: 1.00



Cust Item ID:

Required Date: 7/16/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CL

Date: 10/7/11

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3119

Rev B

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 12192 □ D3119-041 Cover Assembly as per Dwg
D3119 □ Supplier: Delastek □ Material: Cream Kydex 100, 0.060 thick □ Material
release note required

CL

10/7/11

(1)

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

10/7/11

(1)

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

10/7/11

FI
-ay

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60267

July 1, 2010 8:17:11 AM



Page 2

Item ID: D3119-041

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Setup Start



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Item Name: Cover Assembly

Start Date: 7/01/10

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Cust Item ID:

Required Date: 7/16/10

Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: 164

0.00



Packaging

Memo

0.00

Packaging

10-7-19 SP

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10.07.19

ME

10-7-19

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Picklist Print

Page 1

July 1, 2010 8:17:10 AM

Work Order ID: 60267

Parent Item: D3119-041

Parent Item Name: Cover Assembly




Start Date: 7/01/10


Required Date: 7/16/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP: A03.02.24 New Issue KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3119-041P  Cover Assembly		Purchased	No			110	Each	0.0000	1	1			

Complete 

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

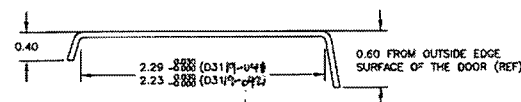
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

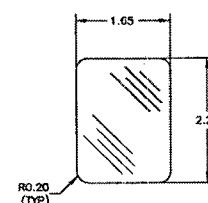
NOTE: Date & initial all entries



RELEASED
04.11.23



SECTION A-A



D3119-3 WINDOW

D3119-1 COVER, LH (SHOWN, REPLACES PREMIER P/N B30-23000-219)

- 1) MAKE FROM TOOL B30-23000-219T
- 2) MATERIAL: CREAM KYDEX 100, 0.060 THICK

D3119-2 COVER, RH (OPPOSITE, REPLACES PREMIER P/N B30-23000-220)

- 3) MAKE FROM TOOL B30-23000-220T
- 4) MATERIAL: CREAM KYDEX 100, 0.060 THICK

D3119-3 WINDOW (REPLACES PREMIER P/N B30-23000-221)

- 5) MATERIAL: LEXAN, 0.060 THICK

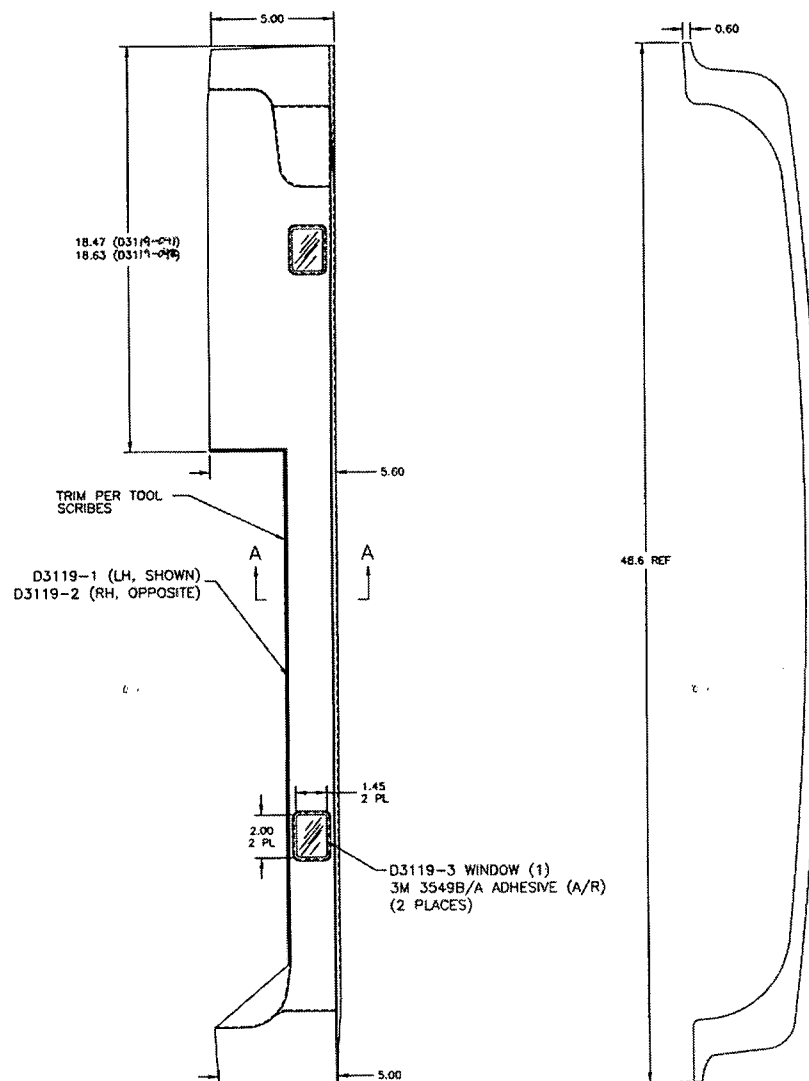
GENERAL NOTES

- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

B	04.11.17	RE-DESIGN
A	02.04.15	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3119
DATE	04.11.17	TITLE COVER ASSEMBLY
		REV. B SHEET 1 OF 1 SCALE NTS

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D3119-041 COVER ASSEMBLY, LH
(SHOWN, REPLACES PREMIER P/N B30-23000-29)
D3119-042 COVER ASSEMBLY, RH
(OPPOSITE, REPLACES PREMIER P/N B30-23000-30)

C2 10/7/01
W10:60267



Delastek inc.
2699 5e avenue
Local 14, Porte -A-
Grand-Mère, Québec G9T 5K7
Can ** Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	33993
Customer #	DART US

Telephone: (819) 533-5788
Warehouse: MAIN

Bill to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Ship to:


DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200
Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
Puro Collect		Origin		Net 30 days USA		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
15/07/2010	01/07/2010	14646	Chantal Lavoie		PO12192		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	<u>DKC135-0001</u>	Line 1 D3119-041 Cover Assy SN: B60267 U de M : Each Dwg Rév.: B <div>No. lot 27122</div> <div>Qté 1</div>			
1	0	1	DKC135-0002	Line 2 D3119-042 Cover Assy SN: B60268 U de M : Each Dwg Rév.: B <div>No. lot 27520</div> <div>Qté 1</div>			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by: 
Quality department AQ-357





Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO12192

Purchase Order Date 7/01/10

PO Print Date 7/01/10

Page Number 1 of 1

Order From :

VU-DEL003

DELASTEK INC
2699 SE AVENUE, LOCAL C.P 123

GRAND-MERE, QC G9T 5K7
CA

REVISED

Contact Name

Vendor Phone

819 533 5788

Vendor Fax

819 533 3494

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

USD

FOB

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3119-041P	Cover Assembly	7/16/10 Yes	1.00 Each	Purolator ground	\$105.0000	\$105.00
		Special Inst:	AS PER DWG D3119 REV. B B60267 MATERIAL: CREAM KYDEX 100, 0.060" THICK				
2	D3119-042P	Cover Assembly	7/16/10 Yes	1.00 Each	Purolator ground	\$105.0000	\$105.00
		Special Inst:	AS ABOVE B60268				

PO Total:

\$210.00

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

CZ

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 2

Change Date: 7/01/10

Date: Lundi, 2010-06-14 14:43:29
Utilisateur: marc dubé

Feuille de Procédé

Client	: DART US DART AEROSPACE LTD	Nom Dessin	: COVER ASSY
Numéro Job	: 27122	Numéro Article	: DKC135-0001
Numéro Soumission	: 4138	Numéro Dessin	: D3119
Numéro B.A.	:	Projet Numéro	: DKC135
Cette fois	: 2010-06-14 No. B.V. :	Révision dessin	: B
Prsht Rev.	: NC	Matériel	: Kydex 100 beige .060" Thk
Prem. fois	: - - Type :	Date Dûe	: 2010-06-21 Qté:
Job précédente	:		
Écrit par	:		
Vérifié & Approuvé par	:		
Commentaires	N° de pièce Laminée Dart Aerospace: D3119-041 N° de pièce Delastek Aeronautique: DKA359-0005 N° de pièce Delastek Composites: DKC135-0001		

Process Sheet Rév.: 00 Création du premier dans DKA à partir de la
Rév.: 03 de DKC



Split Batch 27122-1
30 juin 2010 I.U. 1 pièce



UdM: UNITE

56.

Produit additionnel

Numéro Job:



Séq.:

Machine ou Opération:

Description:

1.0

AMB0208

Kydex 100 cream 0.060" thick

Commentaire Qty.: 0.36 FEUILLE(s)/Unit Total: 0.36 FEUILLE(s)

Kydex 100 cream 0.060" thick

N° de Lot: 1-5838-1

2.0

SORTIE MATÉRIEL

Sortir le matériel du magasin



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Sortir le matériel du magasin

Date: 16/06/10 Sceau:



3.0

THERMOFORMAGE

Thermoformage / Découpe primaire



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Thermoformage des pièces.

Monter le set-up du moule de thermoformage N° DKG 359-504 sur le thermoformeur 4' x 8'.

Tailler le matériel selon les dimensions requises:
16" x 62" x .060" Thk.

Thermoformer la pièce B30-23000-219.

Autocontrôle de fabrication. (Visuel et épaisseur)

Date: Lundi, 2010-06-14 14:43:29
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 27122

Nom Dessin: COVER ASSY
Numéro Article: DKC135-0001

Numéro Job:



Séq.:

Machine ou Opération:

Description:

Quantité: 5 Date: 16/06/10 Sceau: 12

Quantité: Date: Sceau:

4.0

TRIMAGE

Trimage / Rivetage



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Trimage de finition

Faire le découpage primaire sur la scie à ruban.

Faire le trimage de la pièce selon la ligne tracée sur le moule (elle doit apparaître sur la pièce) et selon le dessin page 21 (Pour les trous).

Autocontrôle de fabrication. (Visuel et selon le moule)

Déburrer.

Quantité: 5 Date: 21-06-10 Sceau: 72

Quantité: Date: Sceau:

5.0

AMB0209

Lexan 9034 0.060" thickness

Commentaire Qty.: 0 FEUILLE(s)/Unit Total: 0 FEUILLE(s)

Lexan 9034 0.060" thickness

N° de Lot: B8663

6.0

TRIMAGE

Trimage / Rivetage



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Taillage du matériel.

Sur la banc scie, tailler les B30-2300-221 selon les dimensions du dessins (1.65" x 2.20") et faire des rayons de .20" au quatre coins.

Ébavurer.

Autocontrôle de fabrication. (Visuel et selon le dessin)

Quantité: 5 Date: 21-06-2010 Sceau: 72

Quantité: Date: Sceau:

Date:
Utilisateur:

Lundi, 2010-06-14 14:43:29
marc dubé

Feuille de Procédé

Cient: DART US DART AEROSPACE LTD

Nom Dessin: COVER ASSY

Numéro Job: 27122

Numéro Article: DKC135-0001

Numéro Job:



Séq.:

Machine ou Opération:

Description :

7.0

AAC0562

3549 B/A adhesive kit 2oz.

Commentair Qty.: 0.00 UNITE(s)/Unit Total: 0.00 UNITE(s)

3549 B/A adhesive kit 2oz.

N° de Lot: 1-27869-2

8.0

PRÉPARATION.

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run: 0.0000Hrs

Préparation du matériel.

Faire le mélange de l'adhésif 3549 B/A selon les instructions inscrites sur le contenant.

Date: 29-06-10

Sceau :



9.0

ASSEMBLAGE

Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Assemblage général des pièces

Assembler les deux B30-23000-221 Window sur le B30-23000-219 à l'aide de l'adhésif 3549 B/A et laisser sécher pendant 16 heures.

Autocontrôle de fabrication. (Assemblage)

Quantité :

5

Date

29-06-10

Sceau :



Quantité :

Date :

Sceau :

10.0

INSPECTION

Inspection générale



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Inspection générale

Faire l'inspection de la pièce selon le dessin.

Quantité :

4

Date :

15-7-10

Sceau :



Quantité :

Date :

Sceau :

Split Batch etc: 1
27122-1
30 Jun 2010

RNC: 4770



Inverser séq. 10 et séq. 11 14/07/2010 NG

Date: Lundi, 2010-06-14 14:43:29
Utilisateur: marc dubé

Feuille de Procédé

Cliant: DART US DART AEROSPACE LTD
Numéro Job: 27122

Nom Dessin: COVER ASSY
Numéro Article: DKC135-0001

Numéro Job:



Séq.:

Machine ou Opération:

Description :

11.0

IDENTIFICATION

Identification à encre indélébile



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Identification des pièces.

Faire l'identification : N° de pièce : D3119-041

Date de fabrication :

N° de Work Order:

Sceau d'inspection

15-07-2010

27122

Autocontrôle de fabrication. (Visuel de l'identification)

Quantité :

4

Date :

15-7-10

Sceau :



Quantité :

Date :

Sceau :

12.0

EMBALLAGE

Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Emballage & Entreposage

Emballer les pièces individuellement dans un sac en polythène et entreposer au besoin en attendant la livraison vers le client.

Quantité :

4

Date :

15/7/10

Sceau :



Quantité :

Date :

Sceau :